

DEPARTMENT OF TRANSPORTATION**DIVISION OF ENGINEERING SERVICES**

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:** Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-001516**Date Inspected:** 26-Feb-2008**Project Name:** SAS Superstructure**OSM Arrival Time:** 630**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1400**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Chen Xi**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Deck Panel & PMT**Summary of Items Observed:**

Caltrans Quality Assurance (QA) Inspector, Mike Hasler was present to observe the fitup, welding and related activities associated with the fabricating of Caltrans Mock-up, 77M, 89M, 114M and U-Rib Trial Assembly, for the San Francisco Oakland Bay Self Anchored Suspension Bridge, at Zhenhua Port Machinery Company (ZPMC) facility on Changxing Island.

Item Description	WBS	Dwg No.	Status
1 Deck Panel & PMT	NA	NA	Work in Progress

OBG Bay 1--Production Monitoring Test (PMT) #13 for closed rib welding on Deck Plates DP-020-001 and

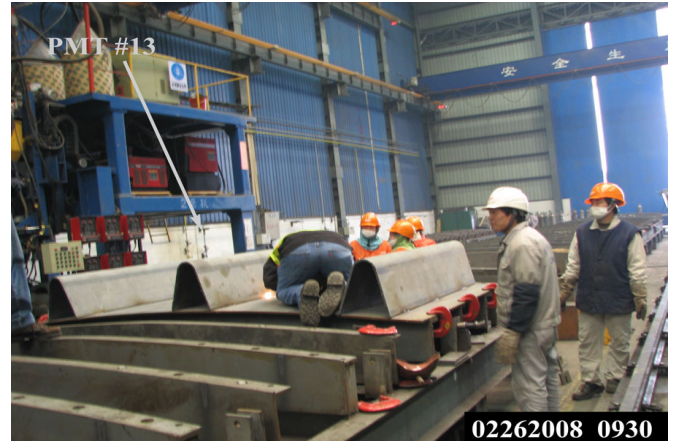
DP-064-001. Gas Metal Arc Welding (GMAW) and submerged arc welding (SAW) is being performed with a gantry that has been recently numbered as 1 (previously noted as gantry 2) and is located near the main central part of this bay.

The GMAW of the production monitoring test is being performed in sequence with the welding of the deck plate DP-020-001 and prior to the welding of the GMAW root weld pass. Caltrans QA performed random visual inspection of the weld joint detail, tack welds, workmanship and was in conformance with the project specification requirements.

Caltrans QA observed that the GMAW root pass was applied to the PMT and to DP-020-001 during Caltrans QA presence. There was no GMAW or SAW performed of DP-064-001 during Caltrans QA inspector's presence. Caltrans QA Inspector performed visual (VT) and ultrasonic testing (UT) of PMT #12 that was welded on 02-25-2008 and accepted by ZPMC. The ultrasonic testing of the closed rib PJP groove welds met the 80% depth of penetration requirements. See Caltrans Ultrasonic Test Report (TL-6027) dated 02-26-2008 for addition information. The following digital picture illustrates the PMT #13 and deck panel DP020-001 at gantry #1.

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Summary of Conversations:

As identified within the contents of this report.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Hasler, Mike	Quality Assurance Inspector
Reviewed By:	Cuellar, Robert	QA Reviewer
